

Work Order ID 85552

Monday, June 11, 2012 10:07:26 AM

WOC 11
85552

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 6/8/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/21/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MLJ* Date: *12/06/12* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3915	C

100 Weld per dwg A/R Aluminum rod Batch: *M120854*
100 Large Fab Memo 0.00
 Large Fab 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.
 Large Fab ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****
 2- weld hinge, label plate and Mounting plates as per dwg D3915

P112-06-19

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00
 Quality Control

1 0 BE12-06-21
12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

AK 12.06.22

155

QC6- Inspect dimensions to drawing

0.00

155

QC

Memo

0.00

Quality Control

inspect fit of lid with base

1 12.06.25

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

1.76 12.6.25

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to IST COAT: 120022 START TIME: 10:40 OVEN TEMPERATURE: 320 FINISH TIME: 11:10 ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

Pick Kit 1x SP 12-6-25

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ 12/06/26
MF 1206-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, June 11, 2012 10:07:25 AM

Page 1

Work Order ID: 85552

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/8/2012

Required Date: 6/21/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No			100	Each	18.0000	4	4		CPL 12.06.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				84820		10							
				WA005		8							
				82668		8							
D3915-1 Rib		Manufactured	No			100	Each	0.0000	2	2		384232 → CPL 12.06.18	
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	6.0000	3	3		CPL 12.06.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				84821		6							
D4019-3 Rib		Manufactured	No			100	Each	5.0000	3	3		CPL 12.06.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				63667		0							
				83798		5							
D4035-045 Lid Rib Assembly, Fwd (Light)		Manufactured	No			100	Each	7.0000	1	1		CPL 12.06.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
				63668		0							
				74466		3							
				84688		4							

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Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 6/8/2012

Required Date: 6/21/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-047 Manufactured No 100 Each 2.0000 1 1

Lid Rib Assembly, Aft (Light)

Pl 12.06.18

Location Loc Qty Loc Code

WA006 2
74809 2

①

D4056-1 Manufactured No 100 Each 2.0000 1 1

Label Plate

Pl 12.06.18

Location Loc Qty Loc Code

WA005 2
84866 2

384140 → ①

D2728-1 Manufactured No 180 Each 0.0000 1 1

Dart Logo label

D4029-041 Manufactured No 180 Each 9.0000 1

Webbing (Long Basket)

SP

Location Loc Qty Loc Code

st503 9
83655 4
84417 5

1x

MS20600-AD4W3 Purchased No 180 Each 742.0000 34

Cherry Rivets

SP 12-6-25

Location Loc Qty Loc Code

ST321 609
111636 36
117601 3
118626 312
120308 258
WA018 133
107939 133

M122151 28x

Lex

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Page 3

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Start Date: 6/8/2012

Required Date: 6/21/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN416J

Purchased

No

180

Each

113.0000

34

34

Washer

Location

Loc Qty

Loc Code

ST297

113

114597

43

13910

70

34x

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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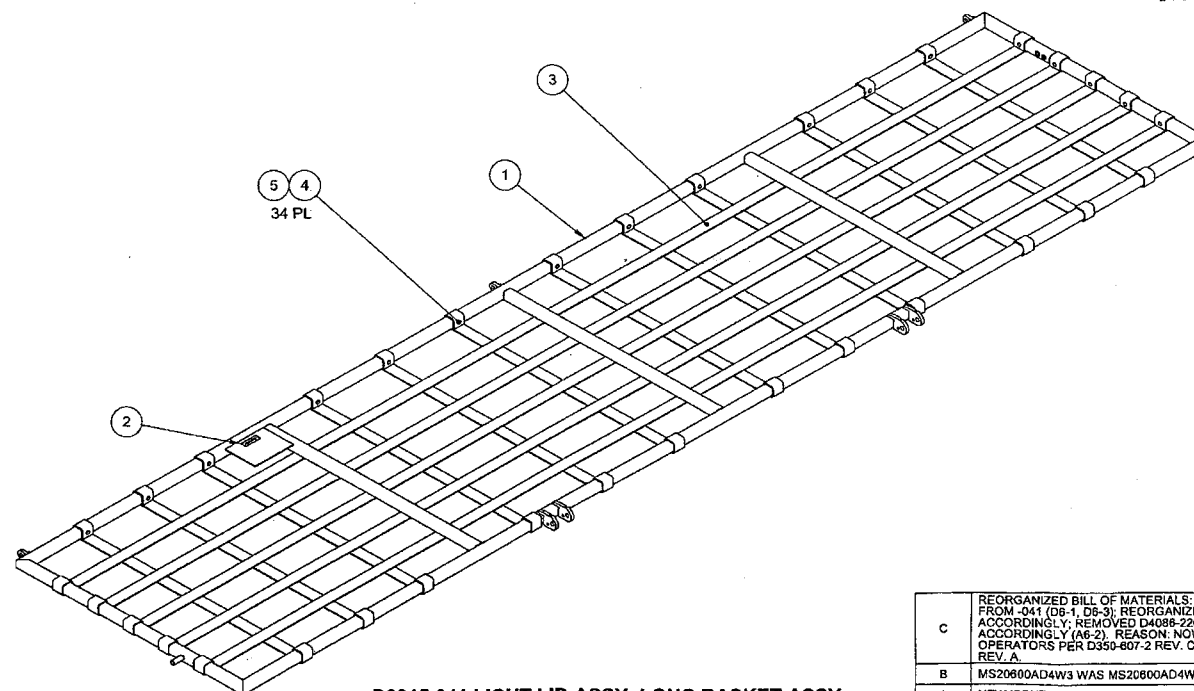
NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 85557 MJS

12/06/12



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
10.08.12
ECN 10-596

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (DB-1, DB-3). REORGANIZED VIEWS ON SHEET 3 ACCORDINGLY. REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-807-2 REV. C AND D350-807-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SA		
CHECKED	SA	DRAWING NO.	REV. C
MFG. APPR.	SA	D3915	SHEET 1 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

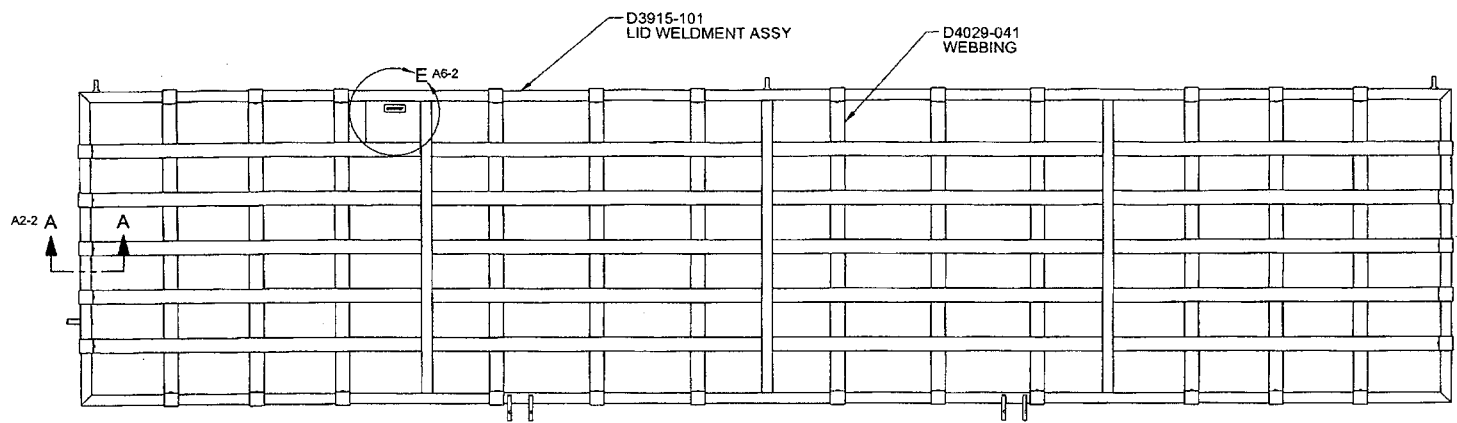
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

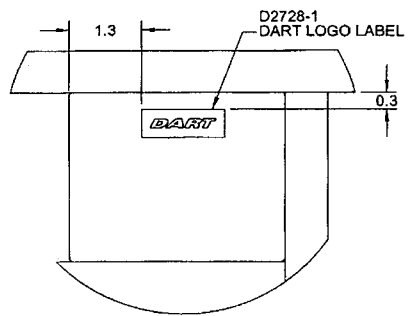
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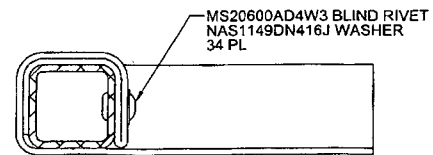
25552



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3915	REV. C
MFG. APPR.	SC	SHEET 2 OF 4	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET	
DATE	10.08.05	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

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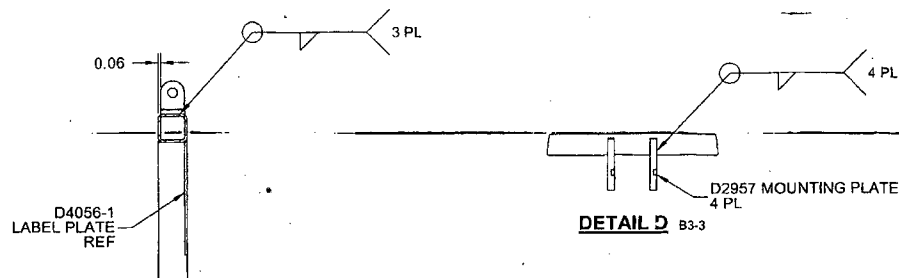
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

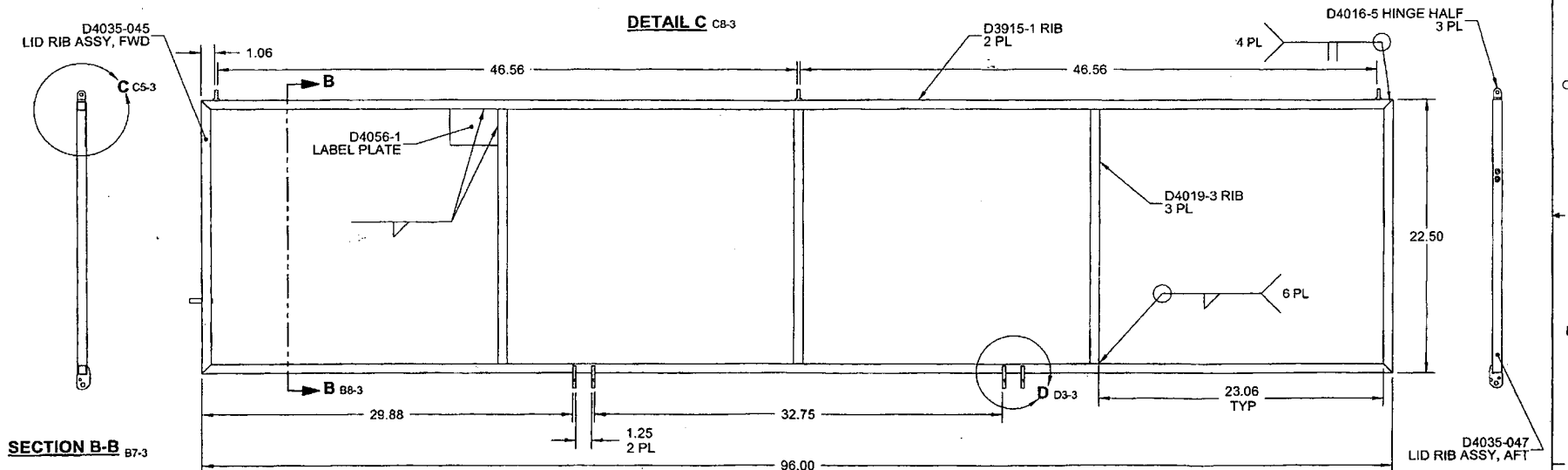
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ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



2552



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3915	REV. C
MFG. APPR.	SC	TITLE	SHEET 3 OF 4
APPROVED	SC	SCALE	
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET	INTS
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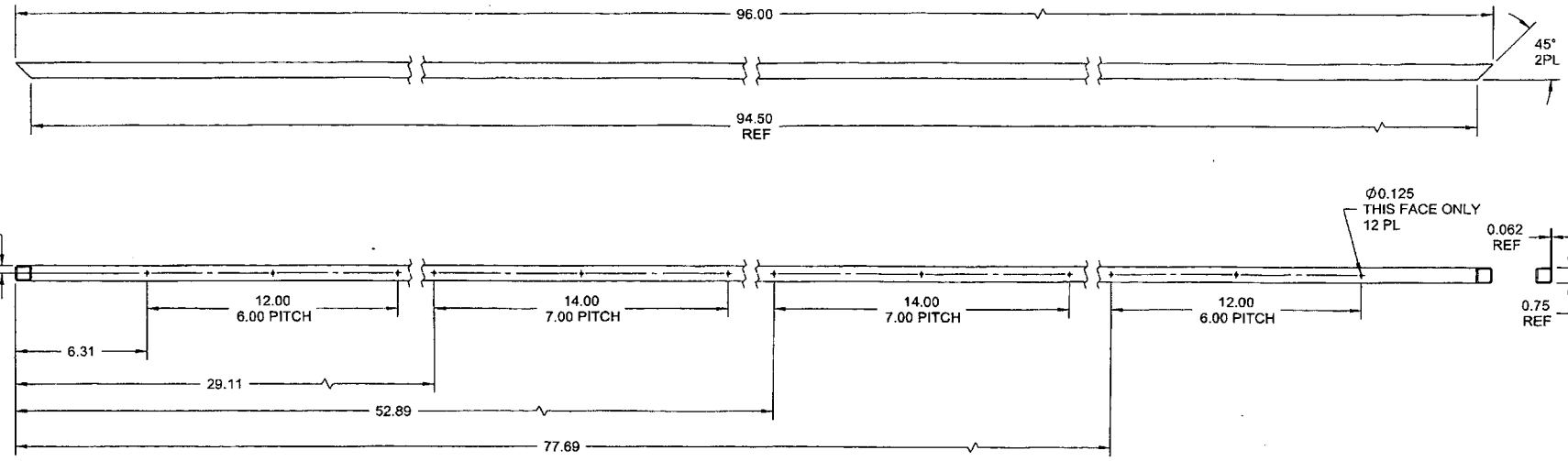
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85552



D3915-1 RIB

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.49 lbs

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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